

Date: Thursday, 23/04/2009 1:36:20 PM  
 User: Julie Dawson

## Process Sheet

<b>Customer</b> : CU-DAR001 Dart Helicopters Services	<b>Drawing Name</b> : 350 SKIDTUBE ASSEMBLY RH
<b>Job Number</b> : 47399 ✓	
<b>Estimate Number</b> : 10265	
<b>P.O. Number</b> :	<b>Part Number</b> : D350636012 ✓
<b>This Issue</b> : 23/04/2009 <b>S.O. No.</b> :	<b>Drawing Number</b> : D2750 REV F
<b>Prsht Rev.</b> : NC	<b>Project Number</b> : N/A
<b>First Issue</b> : // <b>Type</b> : SKIDTUBES	<b>Drawing Revision</b> : F
<b>Previous Run</b> : 47009	<b>Material</b> :
<b>Written By</b> :	<b>Due Date</b> : 08/05/2009 <b>Qty:</b> 1 <b>Um:</b> Each
<b>Checked &amp; Approved By</b> : JLD 09/04/23	
<b>Comment</b> :	
Est Rev: I 02-09-25 Rearranged procedure steps KJ	
Est Rev: J 06-03-29 As per Rev D EC	
Est Rev: K 06-07-13 As per dsi9343 EC	
Est Rev: L 07-07-28 Added SS Wearplates (Rev E) JLM	
Verified By: EC	
Est Rev: M 08-04-22 update steps 4,13 DD verified by: EC	
Est Rev: N 08-09-23 rev F as per dwg DD verified by: ec	
Est Rev: O 09-02-06 apply antiseize on AN8C21A bolts as per PAR09-010 DD verified by: EC	

## Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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HJ for JLD 09/05/08

**Comment:** DOCUMENT CONTROL

Photocopy blue file and type labels per PPP D350-636-012 CHG 004

2.0	D26003BENT	Extrusion Bent
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2600-3-Bent

Extrusion (Bent)

047133

D M 9-4-27

3.0	D2744	Cap
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**Comment:** Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Cap

Batch: 244892 BE 09/04/27

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

4.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1- Mark cut line on aft end of D2600-3-Bent using Jig DT 8150. Cut to length as per Dwg D2750. Deburr end

2-Drill pilot holes as per Dwg D2750 sheet 5 (D2750-2 details).Drill using drill Jig DT8150 & DT8863 .

3- Mark fwd end for cutting using Drill Jig DT 8150 & DT8863 and cut as per dwg D2750.

4-Drill pilot holes for blade fitting bolts using DT8983. Open to 0.500"

5- locate DT8329 off of blade fitting bolt holes and drill pilot holes blade fitting.

6-Open up holes for Detail K to 0.375" (4 holes per side) blade fitting location holes to 0.500" (total of 4 holes per side) as per dwg D2750. Open holes for ground handling and detail L to 0.500" (8 holes per side)

7-Drill pilot holes for wearplates as per Dwg D2750 using DT8108. Open to 0.297".

8-Open up holes of Detail J to 0.297" (total of 2 holes per side)

9-Weld D2744 Cap as per Dwg D2750 and QSI 004.Fill grooves in bend left from bending as per QSI 004  
A/R Aluminum Rod *m110972* *86 07-04-27*

10-Grind welds flush as per Dwg D2750 *u 9-4-27*

11- scribe batch #. *u 9-4-27*

5.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS *8 09/04/28* *(X)*

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP *8 09/04/28* *(X)*

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1 *Pm 09-04-28* *(D)*

W/O:		WORK ORDER CHANGES					
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Job Number: 47399

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

① 11-4-28

9.0

D2739

350 I Beam



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Web

Batch: B47409

fm 09-04-28(1)

10.0

D34901

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B47118

fm 09-04-29

11.0

D34903

Cross Bolt Spacer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Crossbolt spacer

Batch: B45500

fm 09-04-29

12.0

D2743

Crossbolt Spacer



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Crossbolt Spacer

Batch: B45555

fm 09-04-29

13.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open up holes of Detail L and ground handling to 0.625" (total of 8 holes per side) as per dwg D2750.

2-Open up holes of Detail K to 0.750" (total of 4 holes per side)  
as per dwg D2750.

3-Open float holes to .500" (4 per Side)

4-Chamfer holes of Detail K, L, ground handling and float holes per dwg D2750 (welding instructions on sheet 9)

5-Deburr and blow out all chips from inside of tube

fm 09-04-28(1)

W/O:		WORK ORDER CHANGES					
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Job Number: 47399

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

6-Prepare tube for welding, remove alodine as required.

7-Bond web D2739 in place as per QSI 015

A/R Sikaflex-291

batch: m11081

exp. date: 10-01-20

> fm '09-04-280

8- Weld spacers D3490-1, D3490-3 and D2743 as per dwg D2750 & QSI004

(welding instructions on sheet 9)

A/R

Aluminum Rod

batch:

m110972 BE 09/04/29

9-Grind welds flush as per Dwg D2750

10-Spot face ground handling holes section (total of 4 places per side) as per dwg D2750

11-Deburr holes

- AWM  
9-4-30

14.0

QC10

VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

S 02/04/30 @

15.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 02/04/30 @

16.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

UMD Fd

09/05/05

17.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (Ref. 4.3.5.1) as per Dart QSI 005 4.3

START TIME:

12:55

OVEN TEMPERATURE:

320°

FINISH TIME:

1:25

Fd 09/05/05

W/O:		WORK ORDER CHANGES					
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Job Number: 47399

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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18.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Y1



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION  
Inspect for foreign object per QSI 024

09-05-07

(XU)

19.0

ALS41032225

Insert



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)  
Insert  
Batch: M110768

Y1

20.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1  
1-Install inserts as per dwg D2750

Y1

09-05-07

(XU)

21.0

D2745

Bushing



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)  
Bushing  
Batch: 1145556

Y1

22.0

D37911

Wearplate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearplate  
Batch: B47210

Y1

23.0

D37931

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearshoe  
Batch: B47024

Y1

24.0

D37933

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)  
Wearshoe  
Batch: B47211

Y1

09-05-07

(XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47399

Part Number: D350636012

Job Number:



Seq. #:	Machine Or Operation:	Description :
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25.0	D37941	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B47212

*ju*

26.0	D37943	Gasket
------	--------	--------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Gasket

Batch: B47440

*ju*

27.0	D353525	Wearshoe
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WEARSHOE

Batch: B45715

*ju*

28.0	D353625	Gasket
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

GASKET

Batch: B47011

*ju*

29.0	D35371	Wearpad
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Comment: Qty.: 3.0000 Each(s)/Unit Total : 3.0000 Each(s)

WEARPAD

Batch: B46886

*ju*

30.0	D36311	Washer
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

WASHER

Batch: (3x) B45353 (5x) 47437

*ju*

31.0	D3488042	Blade Fitting Assembly, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Blade Fitting, RH

Batch: B47349

*ju*

09-05-07 *(X)*

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Drawing Name: 350 SKIDTUBE ASSEMBLY RH

Job Number: 47399

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

NAS1611010

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

O-RING

NAS1611-010 batch: \_\_\_\_\_

(or MS28775-010) batch: \_\_\_\_\_

9/1

\*

PFC

33.0

D34921

Plug



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Plug

batch: B46692

9/1

\*

34.0

NAS1611013

O-RING



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

O-RING

batch: M1101029

9/1

\*

35.0

D34923

Plug



Comment: Qty.: 8.0000 Each(s)/Unit Total : 8.0000 Each(s)

Plug

batch: B47473

9/1

36.0

AN3C5A

Bolt



Comment: Qty.: 34.0000 Each(s)/Unit Total : 34.0000 Each(s)

Bolt

Batch: M111424

9/1

37.0

AN3C6A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Bolt

Batch: M110372

9/1

38.0

AN6C44A

BOLT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

BOLT

Batch: M110665

9/1

09-05-07

9/1

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
09-05-07	32.0	Replace "O" ring NAS 1611-010 for D2594.3 B29908	Jel	09-05-07	(X8)		S 09/05/07

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47399

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

39.0

AN8C35A

BOLT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

BOLT

Batch: M110105

Jul

40.0

AN960C10L

washer



Comment: Qty.: 38.0000 Each(s)/Unit Total : 38.0000 Each(s)

washer

Batch: M111548

Jul

41.0

AN960C816L

WASHER



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

WASHER

Batch: M1110139

Jul

42.0

MS210436

NUT



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

NUT

Batch: M1110584

Jul

43.0

MS21083C8

NUT



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

NUT

Batch: M1110584

Jul

44.0

NAS1515H3L

WASHER



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

WASHER

Batch: M1110806

Jul

45.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Inspect for Foreign Objects

2-Spray inside of tube with "LPS-3"  
batch: X

Jul

09-05-07

(XU)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47399

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

3-Install blade fitting D3488-042, wearshoes and ground handling hardware as per dwg D2750

SIKA FLEX 241

BATCH: M111081

EXP DATE: 10/20

4-assemble o'ring to plug as per dwg D3492 and apply o'ring lube

A/R 55-o'ring lube batch: M101223

5-Coat all exposed fasteners with "LPS Procyon"

batch: M104251

9/1 09-05-07

(X)

46.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

507/05/07

47.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

48.0

D2741

Blade, 350 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Blade

Batch: B45320

9/5/8

sq

49.0

AN960C816L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Washer

Batch: M111424

9/5/8

sq

50.0

MS21083C8

NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Nut

Batch: M111424

9/5/8

sq

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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Job Number: 47399

Part Number: D350636012

Job Number:



Seq. #:

Machine Or Operation:

Description :

51.0

AN8C21A

BOLT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Bolt

Batch: M110312

\*\*\*\*\*apply antiseize prior to packaging\*\*\*\*\*

Batch: M110658

9/5/8

SP

52.0

NAS1515H8L

WASHER



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: M108164 108964

9/5/8

SP

53.0

D34931

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

WASHER

Batch: B44904

9/5/8

SP

54.0

D35321

Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

spacer

Batch: B44904

9/5/8

SP

55.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

\*\*\*\*\*ensure antiseize is on AN8C21A bolts\*\*\*\*\*

9/5/8

56.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Package as per PPP D350-636-012

9/5/8

SP

57.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

09/05/11

Job Completion



B47399

05-10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

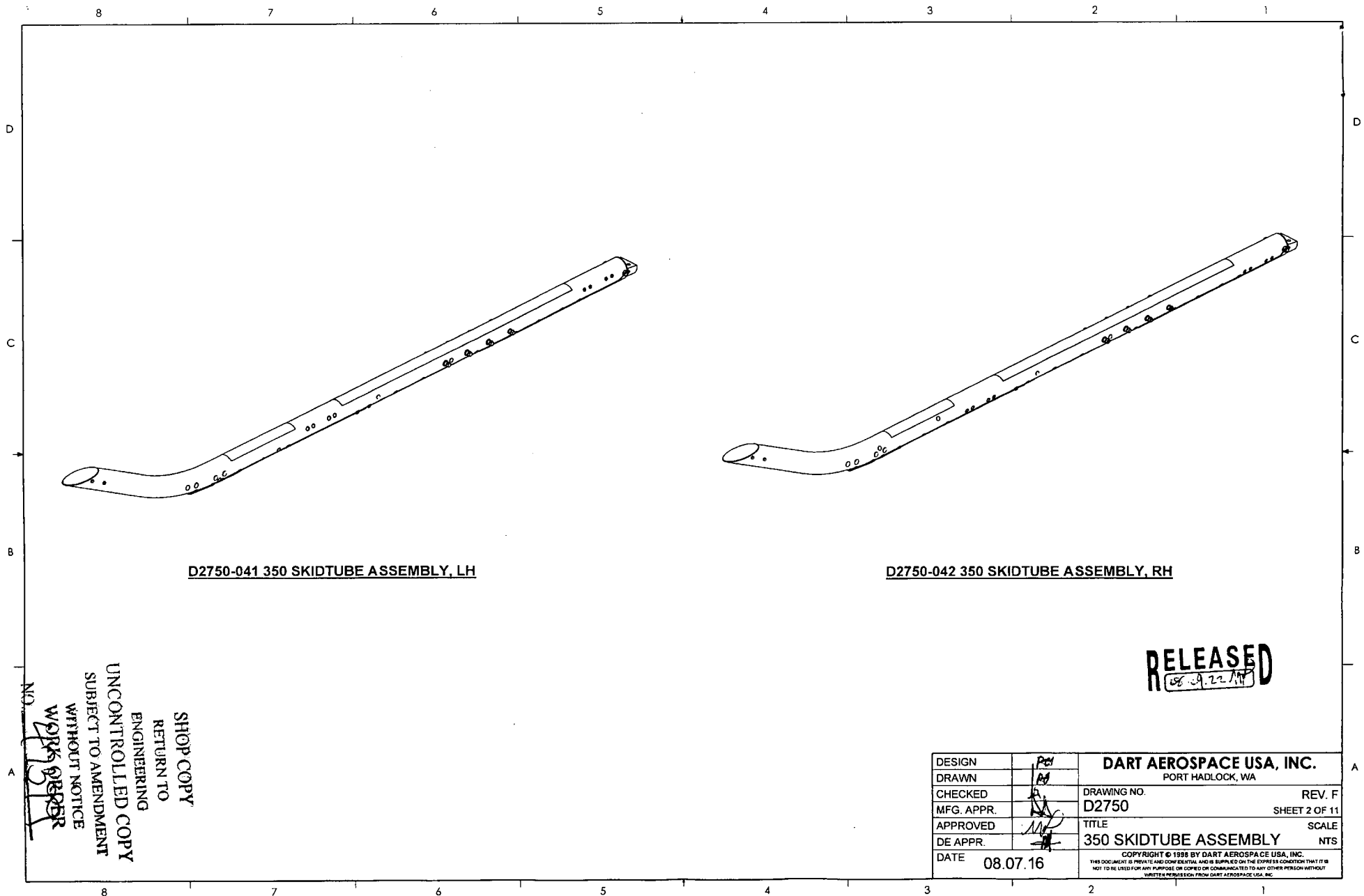
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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**NOTE:** Date & initial all entries

**B**

11) NO. 4734 WORK ORDER

A



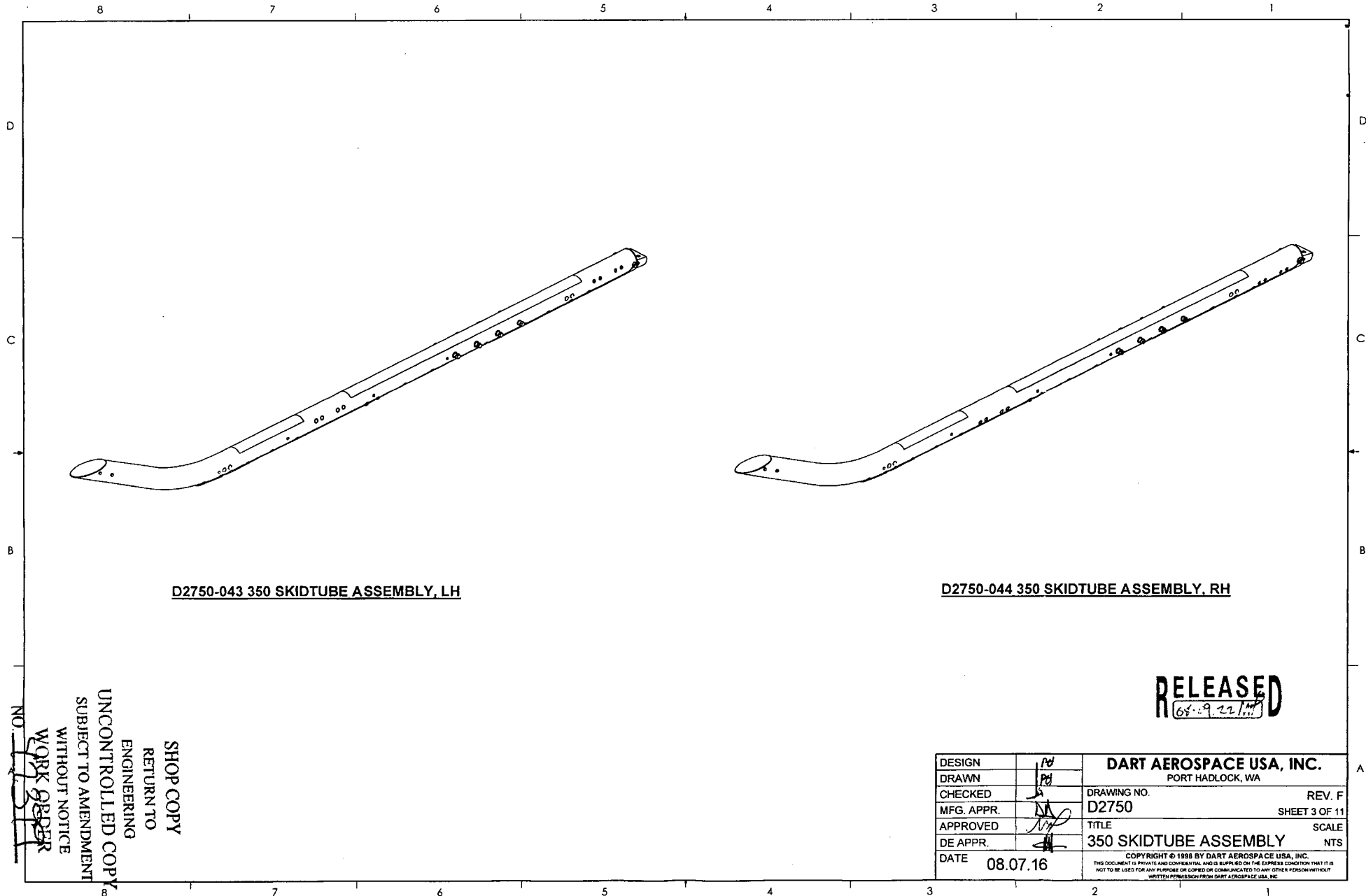
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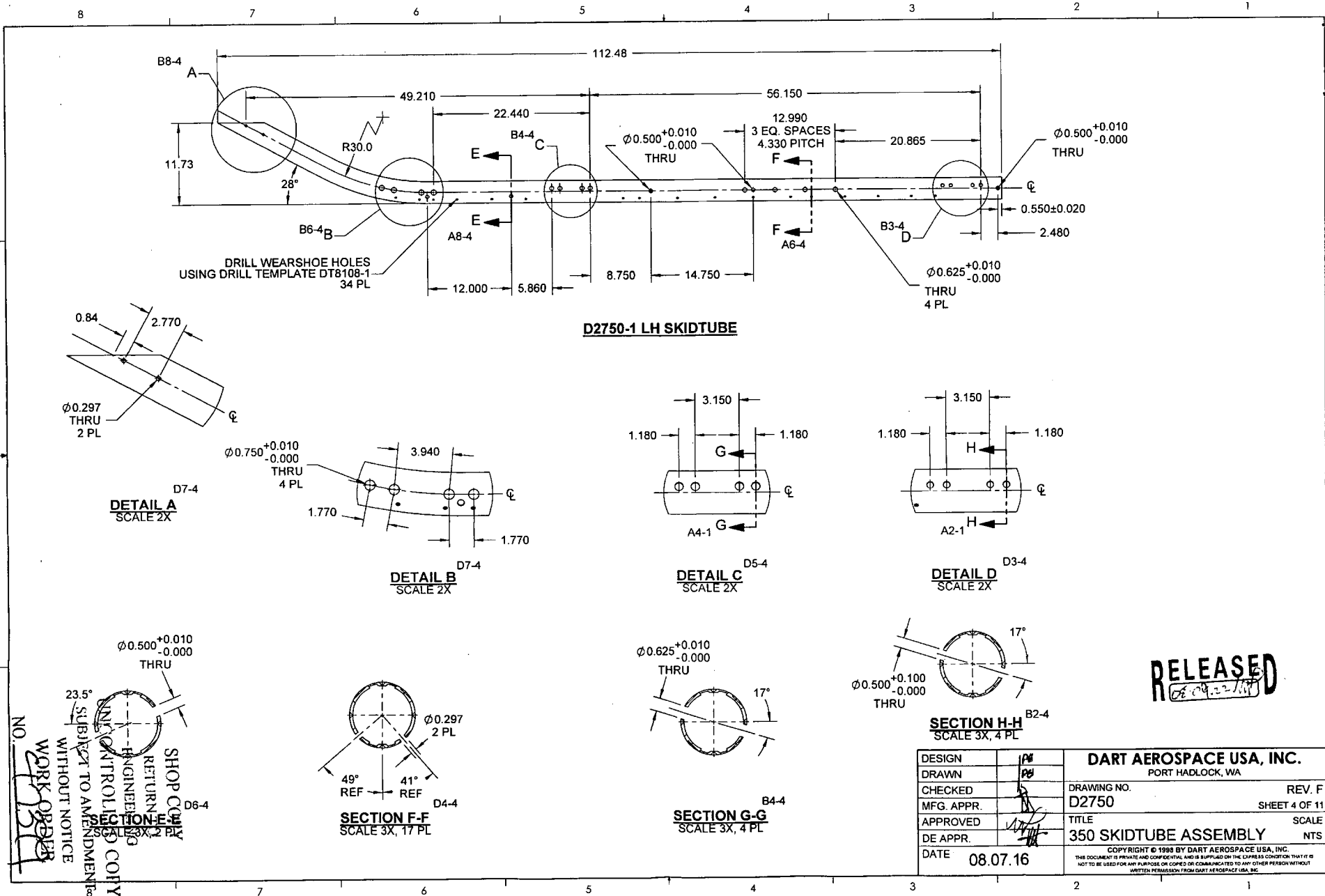
D2750-042 350 SKIDTUBE ASSEMBLY, RH

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MFG. APPR.	AM	D2750	SHEET 2 OF 11
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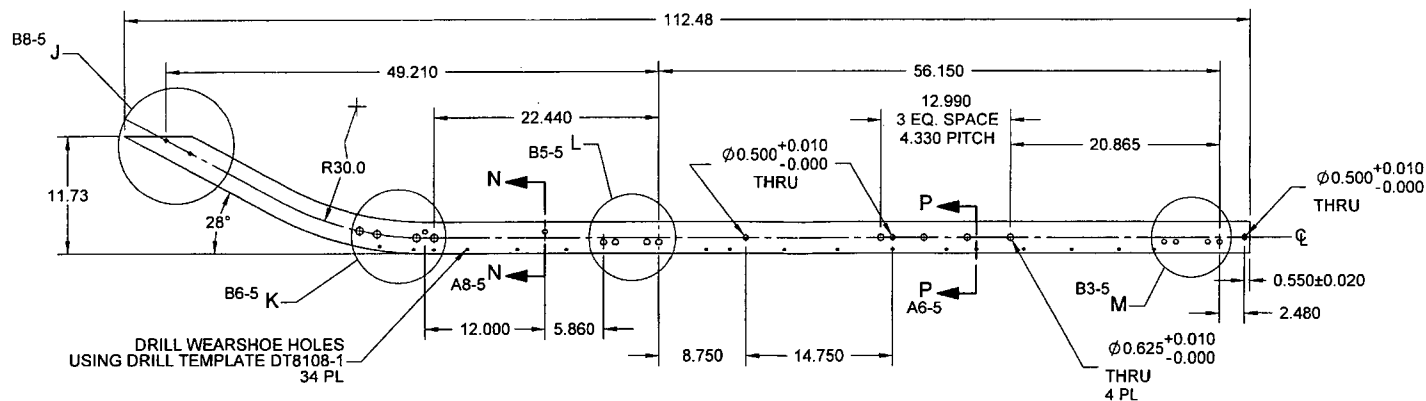


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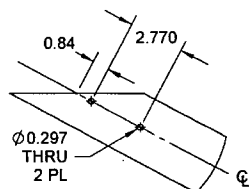
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APPROVED	PH
DE APPR.	PH
DATE	08.07.16

DART AEROSPACE USA, INC. PORT HADLOCK, WA	
DRAWING NO. D2750	REV. F SHEET 4 OF 11
TITLE 350 SKIDTUBE ASSEMBLY	SCALE NTS
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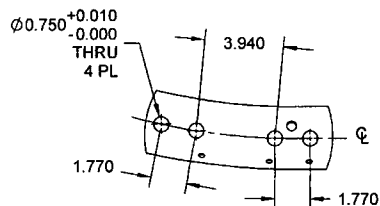




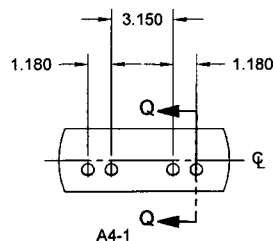
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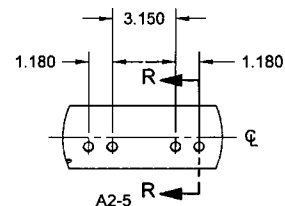
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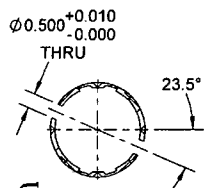
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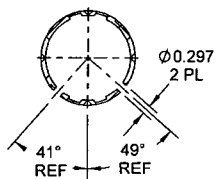
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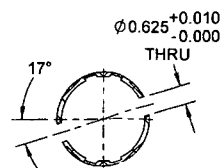
**DETAIL M**  
SCALE 2X



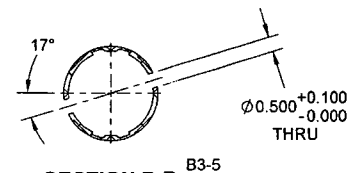
**SECTION N-N**  
SCALE 3X, 2 PL



**SECTION P-P**  
SCALE 3X, 17 PL



**SECTION Q-Q**  
SCALE 3X, 4 PL



**SECTION R-R**  
SCALE 3X, 4 PL

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MFG. APPR.		REV. F
APPROVED		SHEET 5 OF 11
DE APPR.		TITLE <b>350 SKIDTUBE ASSEMBLY</b>
DATE	<b>08.07.16</b>	SCALE NTS

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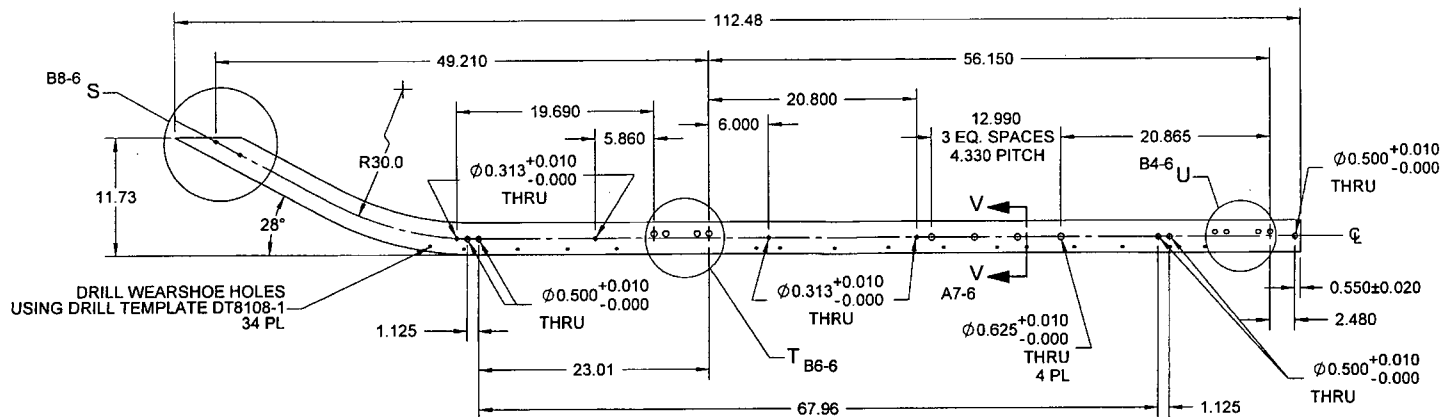
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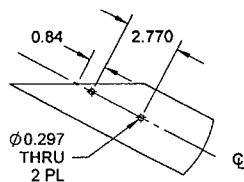
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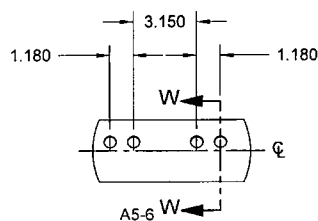
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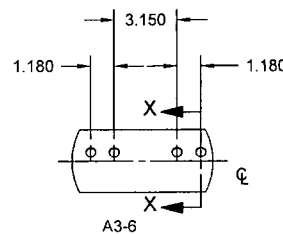
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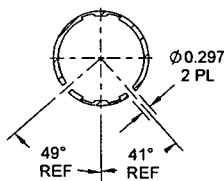
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D8-6



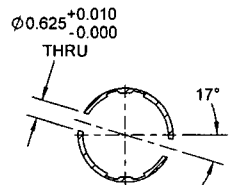
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C5-6



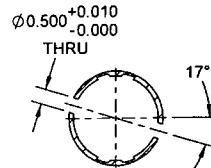
DETAIL U  
SCALE 2X  
D3-6



SECTION V-V  
SCALE 3X, 17 PL  
C4-6





SECTION W-W  
SCALE 3X, 4 PL  
B6-6

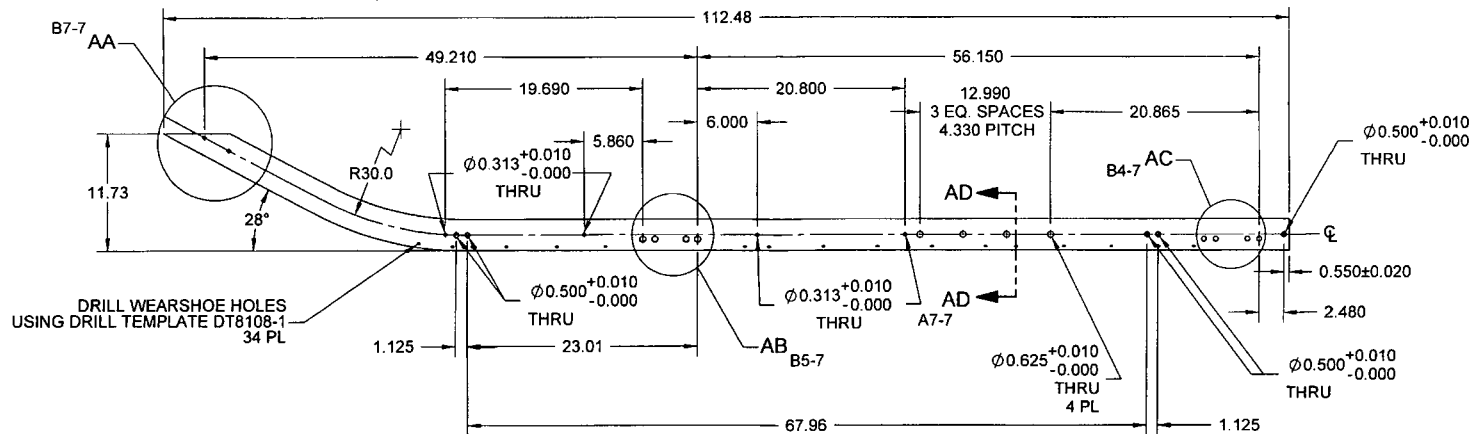


SECTION X-X  
SCALE 3X, 4 PL  
B4-6

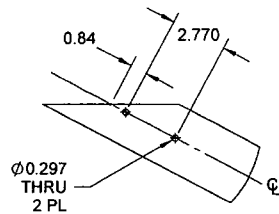
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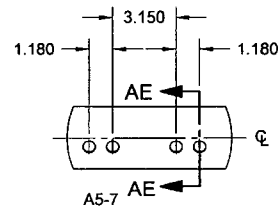
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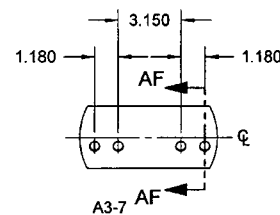
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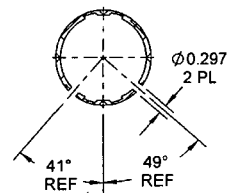
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SCALE 2X



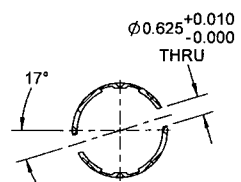
**DETAIL AB**  
SCALE 2X



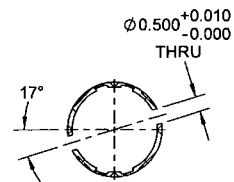
**DETAIL AC**  
SCALE 2X



**SECTION AD-AD**  
SCALE 3X, 17 PL



**SECTION AE-AE**  
SCALE 3X, 4 PL

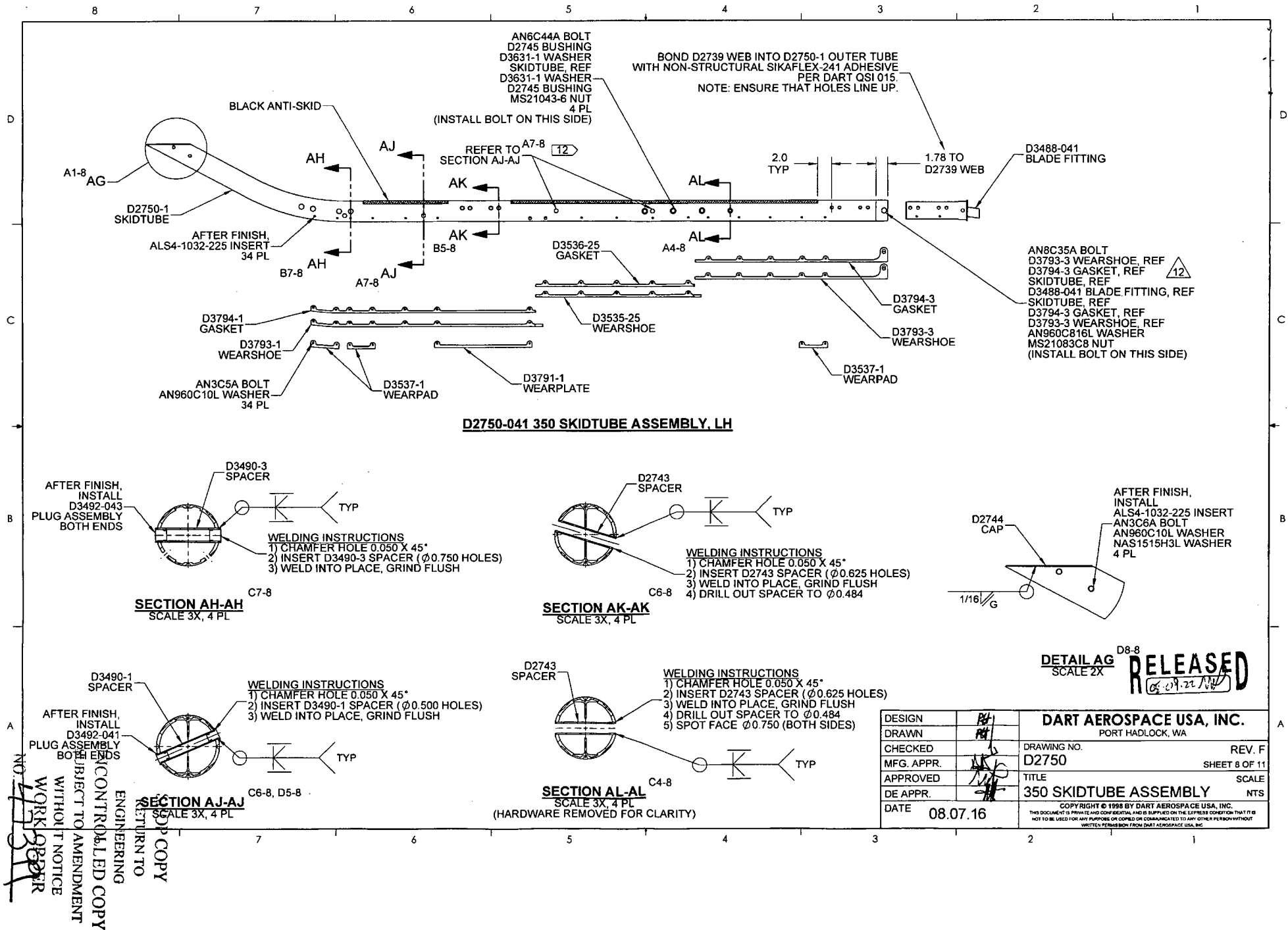


**SECTION AF-AF**  
SCALE 3X, 4 PL

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**D2750-041 350 SKIDTUBE ASSEMBLY, LH**

**SECTION AH-AH**  
SCALE 3X, 4 PL

**SECTION AK-AK**  
SCALE 3X, 4 PL

**SECTION AJ-AJ**  
SCALE 3X, 4 PL

**SECTION AL-AL**  
SCALE 3X, 4 PL

(HARDWARE REMOVED FOR CLARITY)

**DETAIL AG**  
SCALE 2X

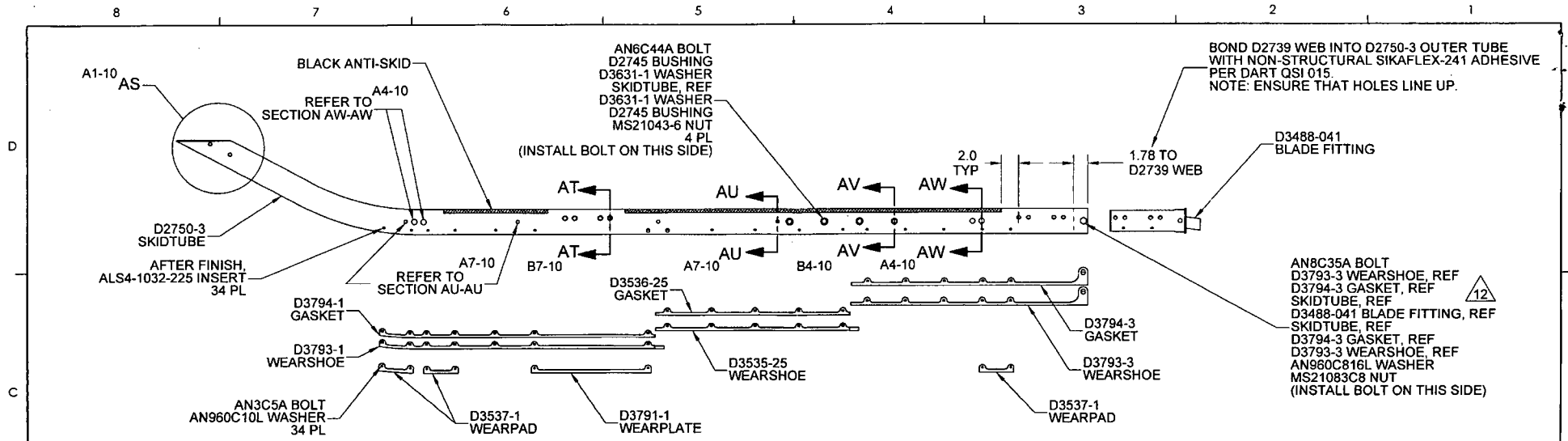
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DATE		08.07.16	

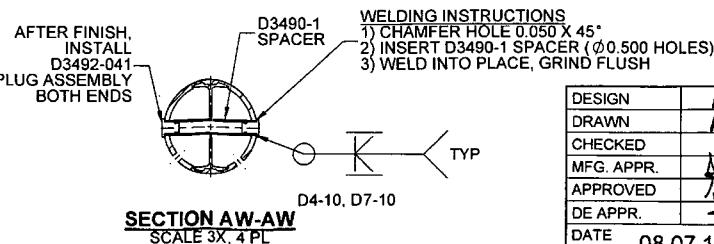
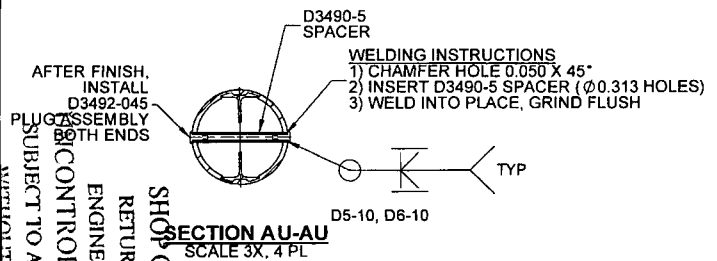
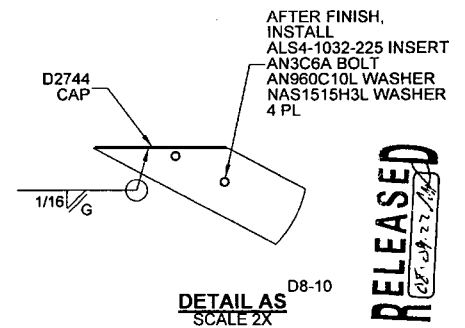
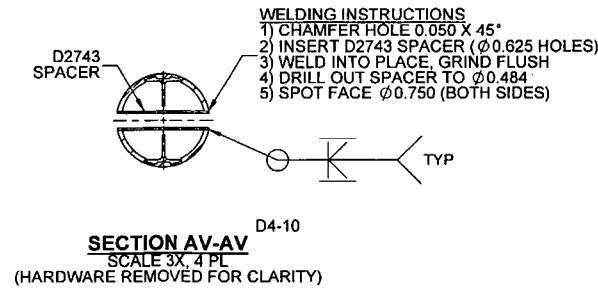
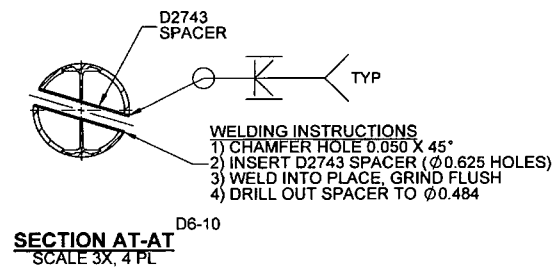
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### D2750-043 350 SKIDTUBE ASSEMBLY, LH

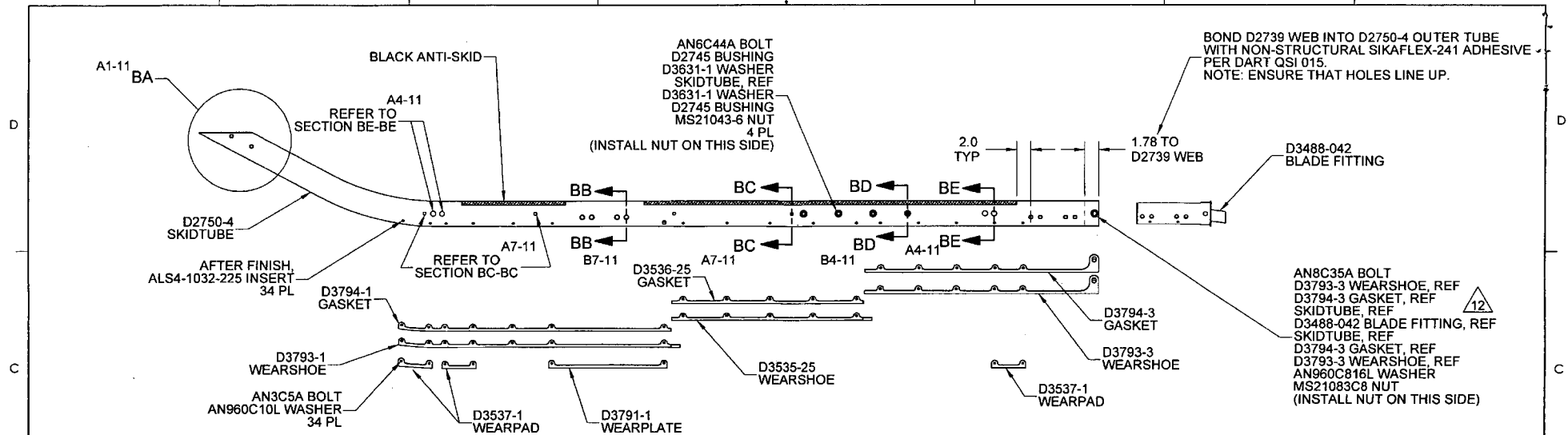


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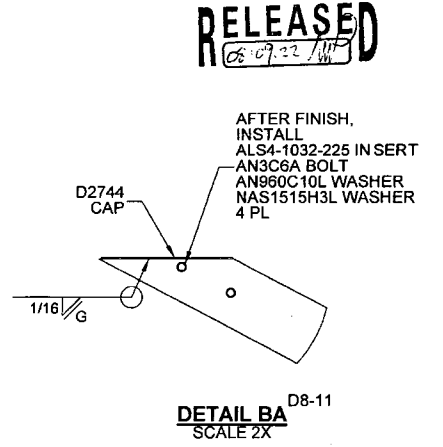
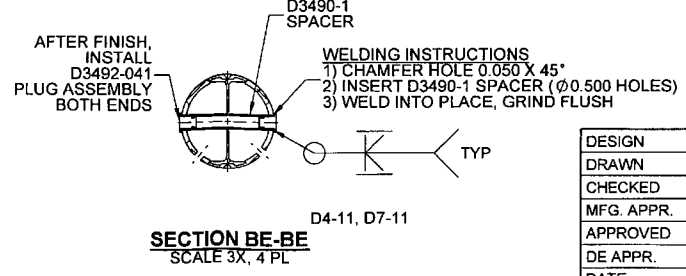
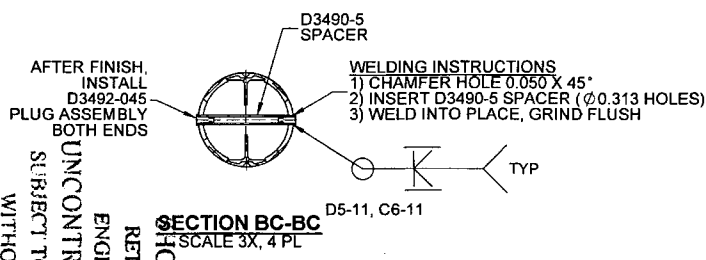
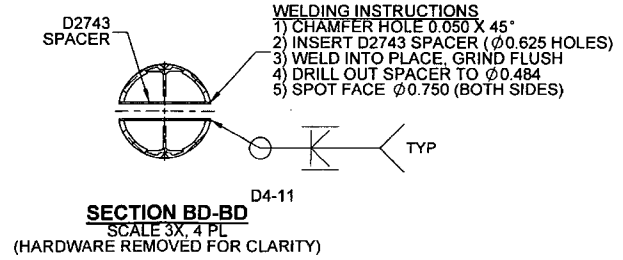
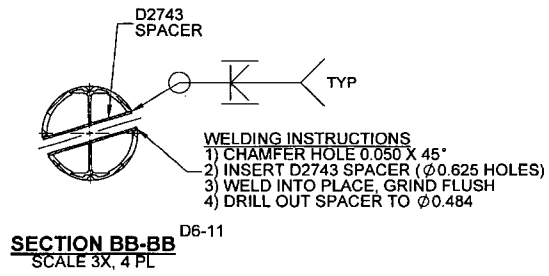
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BOTH ENDS  
AFTER FINISH,  
INSTALL  
D3492-045  
PLUG ASSEMBLY

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08/27/16

8 7 6 5 4 3 2 1



**D2750-044 350 SKIDTUBE ASSEMBLY, RH**



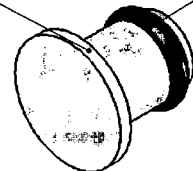
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D3492-XX PLUG  
(SEE TABLE)

NAS1611 PLUG  
(SEE TABLE)



### D3492-XXX PLUG PARTS LIST

QTY -041	QTY -043	QTY -045	QTY -047	QTY -049	QTY -051	QTY -053	PART NUMBER	DESCRIPTION
X							D3492-041	PLUG ASSEMBLY
	X						D3492-043	PLUG ASSEMBLY
		X					D3492-045	PLUG ASSEMBLY
			X				D3492-047	PLUG ASSEMBLY
				X			D3492-049	PLUG ASSEMBLY
					X		D3492-051	PLUG ASSEMBLY
						X	D3492-053	PLUG ASSEMBLY
1							D3492-1	PLUG
	1						D3492-3	PLUG
		1					D3492-5	PLUG
			1				D3492-7	PLUG
				1			D3492-9	PLUG
					1		D3492-11	PLUG
						1	D3492-13	PLUG
		1					NAS1611-005	O-RING
			1				NAS1611-007	O-RING
1							NAS1611-010	O-RING
						1	NAS1611-012	O-RING
	1						NAS1611-013	O-RING
					1		NAS1611-015	O-RING
				1			NAS1611-016	O-RING

△ △ △

#### NOTES:

1) O-RING: POSSIBLE SUPPLIER P/N: NAS1611-XXX OR PARKER 2-XXX







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~~UNDER REVIEW~~

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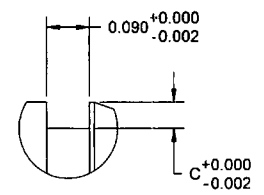
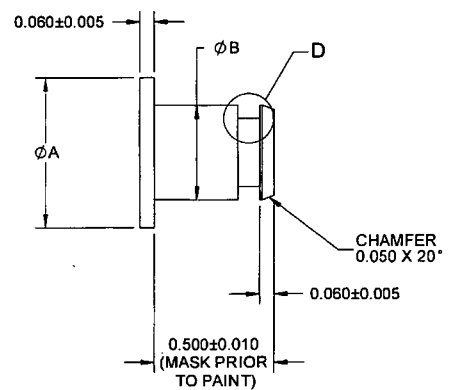
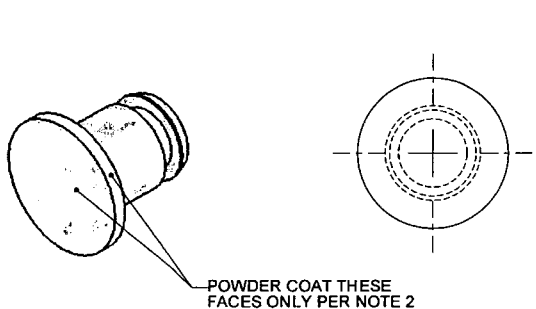
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07.10.16

C	ADD -049/-051/-053, CHANGE DRAWING FORMAT	PH	07.10.05
B	ADD -047; UPDATE DIM A FOR -045	PH	06.05.11
A	NEW ISSUE	PH	06.01.04
REV.	DESCRIPTION	BY	DATE
DESIGN		<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.			
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DATE	07.10.05	SCALE	
		2:1	
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8 7 6 5 4 3 2 1



DETAIL D

D3492-XX PLUG

D3492-XX PLUG MACHINING DETAILS

P/N	A	B	C	MATERIAL SPEC
D3492-1	0.625	0.394	0.055	M6061T6R0.625
D3492-3	0.750	0.582	0.045	M6061T6R0.750
D3492-5	0.375	0.188	0.045	M6061T6R0.375
D3492-7	0.500	0.270	0.045	M6061T6R0.500
D3492-9	0.938	0.750	0.045	M6061T6R1.000
D3492-11	0.850	0.664	0.045	M6061T6R0.875
D3492-13	0.750	0.520	0.045	M6061T6R0.750

- NOTES:
- 1) MATERIAL: ALUMINUM 5052-H32 OR 6061-T6 OR 1100-0 PER QQ-A-225/7 (5052) OR QQ-A-225/8 (6061) OR QQ-A-200/8 (6061) OR QQ-A-225/1 (1100) (REF. DART MATERIAL SPEC M6061T6R0.000)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT WHITE GLOSS (4.3.5.1) PER DART QSI 005 4.3
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: N/A

UNDER REVIEW  
01.01.11  
05M 0.01 ON D3492-13  
REF. C.A. (HOLE SMALLER)  
13508.11.12  
OKay

DEO ATTACHED  
RELEASED  
07.11.16

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MFG. APPR.		D3492	SHEET 2 OF 2
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8 7 6 5 4 3 2 1

DRAWING NO. D3492	TITLE PLUG	REV. C	DART AEROSPACE LTD ENGINEERING ORDER		D.E.O. NO. D3492-C-1	SHEET NO. SHEET 1 OF 1	SCALE NTS
DRAWN AJS	CHECKED	MFG. APPR.	APPROVED		DE APPR.		
DATE 08.11.05	DATE 08.11.05	DATE 08.11.05	DATE 08/11/05		DATE 08/11/05		

SHEET 2 MODIFY -13 PLUG AS SHOWN:

IS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.510	0.045	M6061T6R0.750

WAS:

**D3492-XX PLUG MACHINING DETAILS**

P/N	A	B	C	MATERIAL SPEC
D3492-13	0.750	0.520	0.045	M6061T6R0.750

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. 47399

**RELEASED**  
08/11/10

NO. 197

**AWS D17.1.2001  
QUALIFICATION TEST RECORD**

Name: Barday Elliott  
Job number: 47399  
Part number: D350 636 012  
Description: 350 skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Aluminium  
Current: AC[ ] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Penetration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]

**UNACCEPTABLE**

Cracks:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Undercut:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Pin holes:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Overlap (cold lap)	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Porosity (surface):	pass[ <input checked="" type="checkbox"/> ]	fail[ ]
Coloration:	pass[ <input checked="" type="checkbox"/> ]	fail[ ]

Qualifier <u>P. J. Dent</u>	Date of Test Coupon <u>09-04-27</u>
Welder <u>Barday Elliott</u>	Date of Test Coupon <u>09-04-27</u>

The above named individual is qualified in accordance with AWS D17.1.2001 to weld